

Work Order ID 165829

Wednesday, August 30, 2017 11:42:23 AM

165829

Testing

Page 1

Item ID: D3914-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Long Basket Lid Assembly (350)
Start Date: 8/30/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/6/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: AUG 30 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3914	D
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 3136920 0.00

100

Large Fab

Large Fab

Large Fab

Memo

2.77

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

K CC 17-9-14
* CP

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

D 17-09-14 DAS 9 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120						<u>①</u>	<u>17.09.14</u>		DAS 9 9-89
QC	Memo	0.02							
Quality Control	-Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4								
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1-Powder coat Black Sandtex (4.3.5.7) per Dart QSI 005 4.3								
	2-Mask this area prior to finish View E-E								
	3-Mask holes prior to finish Detail D								
	4-START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								

N/A
17.09.18

P40 →

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>165829</u> Part No. <u>D3914-041</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				8/17/10/10 Completed By n/a Lead hand / Supervisor Approval Verification n/a QC / QA Coordinator Approval 8/17/10/10	
For testing use only D3914-041 B165829 is not to be Powder coated or wing - work as per Dwg.				For Testing use only.					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☒ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☒ Misread ☐ Turning Sequence ☐	
		OTHER :							

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135 *135* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI003 4.4 Batch Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg.	0.00 0.66							
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01							

N/A
12-09-18

Work Order ID 165829

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>wlv</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									

um 12/19/28

POSITIVE RECALL
EFFECTIVE AUG 30 2017
RELEASED _____

AUTH _____
DATE _____

DAS
21
9-89

RD 17-1044-01

Picklist Print

Wednesday, August 30, 2017 11:42:25 AM

Work Order ID: 165829

165829

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/30/2017

Required Date: 9/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS
PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG
REV.C DD VERF:JFS IPP Rev.E 17.06.12 As per Dwg.Rev.D DP
VerifyDD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3914-1 *D3914-1* Rib		Manufactured	No			100	Each	6.0000	2	2			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			6		165478	2		
					165478			6					
✓ D3914-7 *D3914-7* Rib		Manufactured	No			100	Each	12.0000	2	2			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			12		165247	2		
					165247			6					
					165474			6					
✓ D4018-5 *D4018-5* Rib		Manufactured	No			100	Each	9.0000	9	9			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			9		165533	9		
					165248			9					

2 D.M.L 2017-9-5

2 D.M.L 2017-9-5

9 D.M.L 2017-9-5

Picklist Print

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Page 2

Work Order ID: 165829

165829

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/30/2017

Required Date: 9/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

4.0000

2

2

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

B165249 → 2 C 17-09-14

Location

Loc Qty

Loc Code

WA004

4

164946

4

D2581

Manufactured No

100

Each

56.0000

2

2

D2581

Mounting Bracket

**

2 D.M.L 2017-9-5

Location

Loc Qty

Loc Code

WA004

56

161800

10

162923

18

164446

28

D4016-3

Manufactured No

100

Each

37.0000

3

3

D4016-3

Hinge Half, Lid

**

3 D.M.L 2017-9-5

Location

Loc Qty

Loc Code

WA004

37

159570

2

160518

35

D4020-5

Manufactured No

100

Each

1.0000

1

1

D4020-5

Mesh (350 Basket Long, Lid)

**

B163445 → 1 C 17-09-14

Location

Loc Qty

Loc Code

WA004

1

164841

1

Picklist Print

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165829

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/30/2017

Required Date: 9/6/2017

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured

No

100

Each

1.0000

1

1

✓ *D4021-3*

**

Data Plate

I D.M.L 2017-9-5

Location

Loc Qty

Loc Code

WA004

1

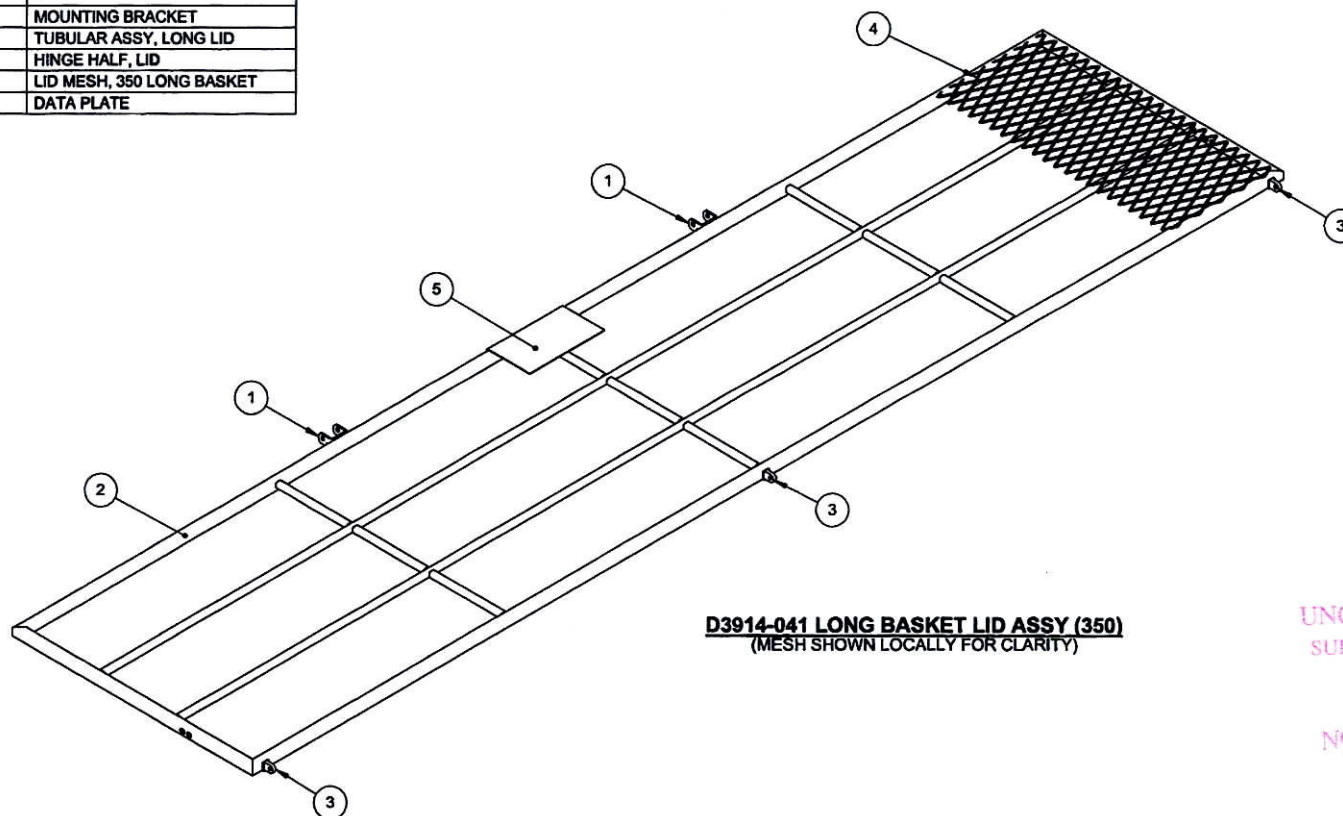
165512

I

160720

1

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	1	D3914-101	TUBULAR ASSY, LONG LID
3	3	D4016-3	HINGE HALF, LID
4	1	D4020-5	LID MESH, 350 LONG BASKET
5	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 165829 MLW
170830

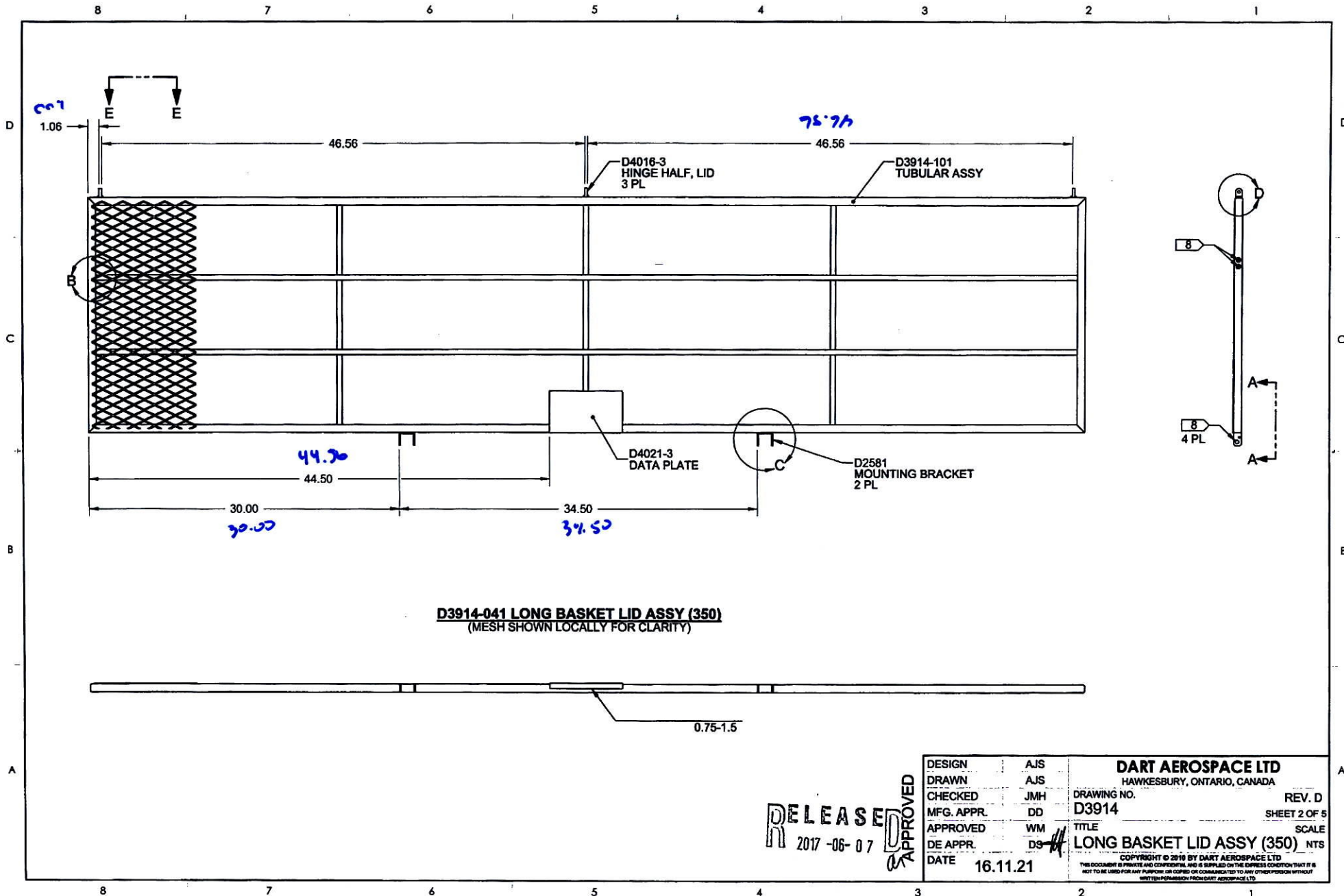
D	SHEET 1: UPDATED NOTE 8 ADDED NOTE 10. D2728-3 DELETED. SHEET 2: SECTION AND VIEW LETTERS UPDATED. ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROFORM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

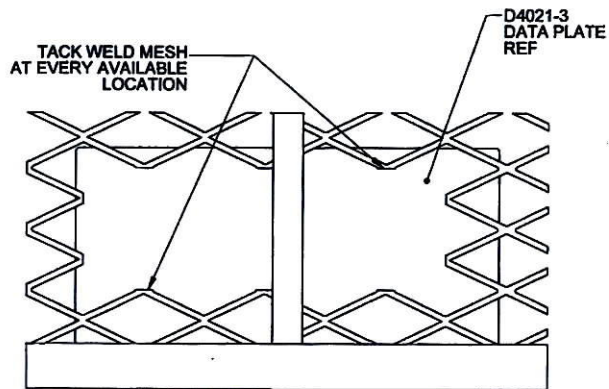
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004
- 10) MASK THIS AREA PRIOR TO FINISH

RELEASED
2017-06-07
EN 17-580

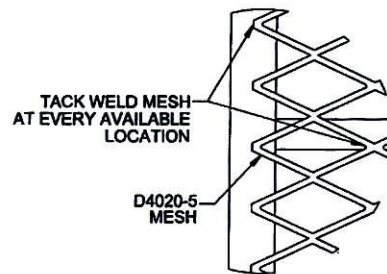
APPROVED



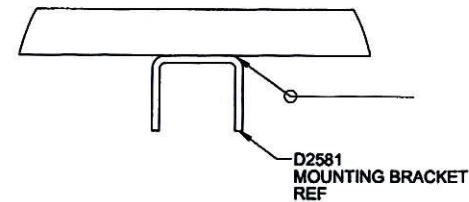
8 7 6 5 4 3 2 1



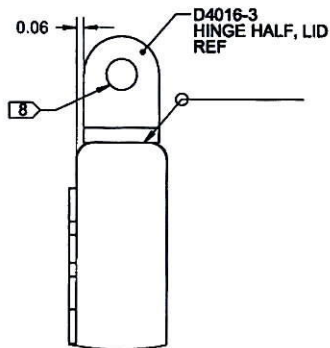
VIEW A-A
SCALE 4X



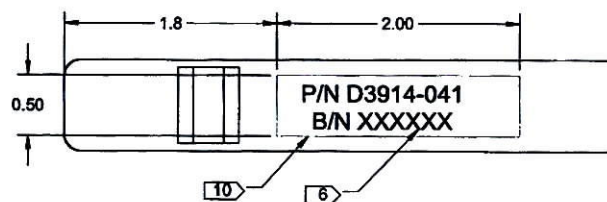
DETAIL B
SCALE 4X



DETAIL C
SCALE 4X
2 PL



DETAIL D
SCALE 8X
3 PL



VIEW E-E
SCALE 8X

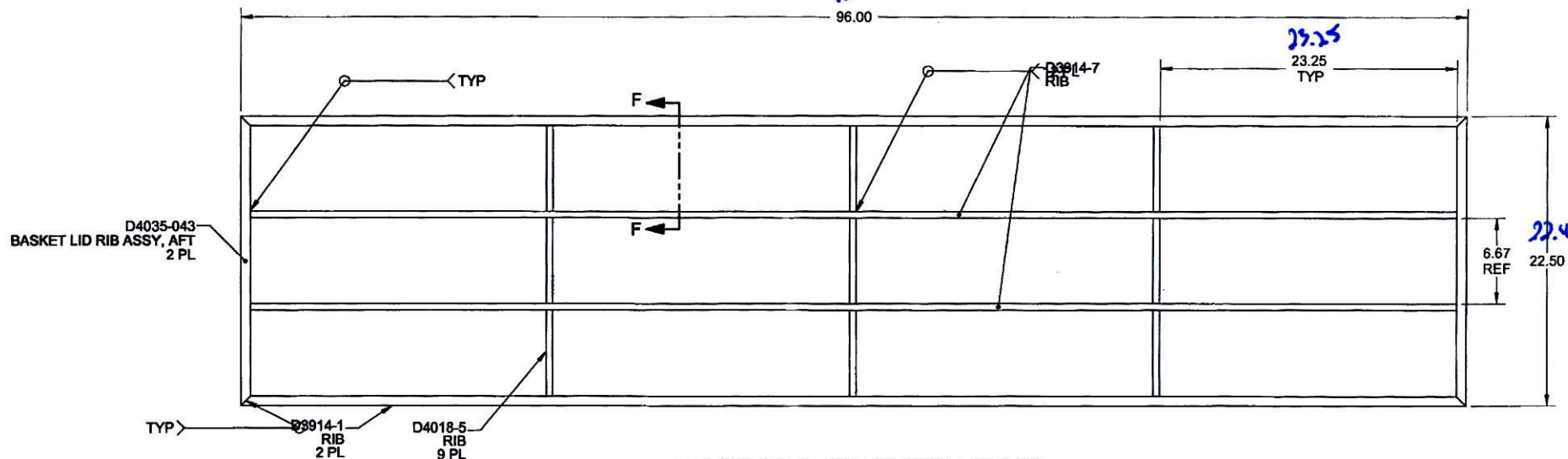
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
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2017-06-07

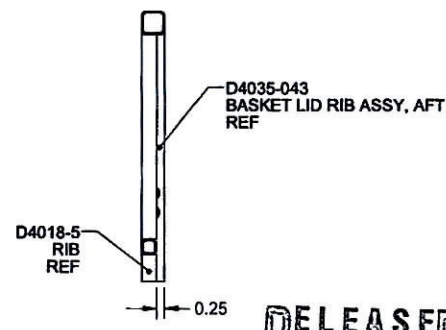
APPROVED

8 7 6 5 4 3 2 1

ITEM	QTY .101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



8 D3914-101 TUBULAR ASSY, LONG LID

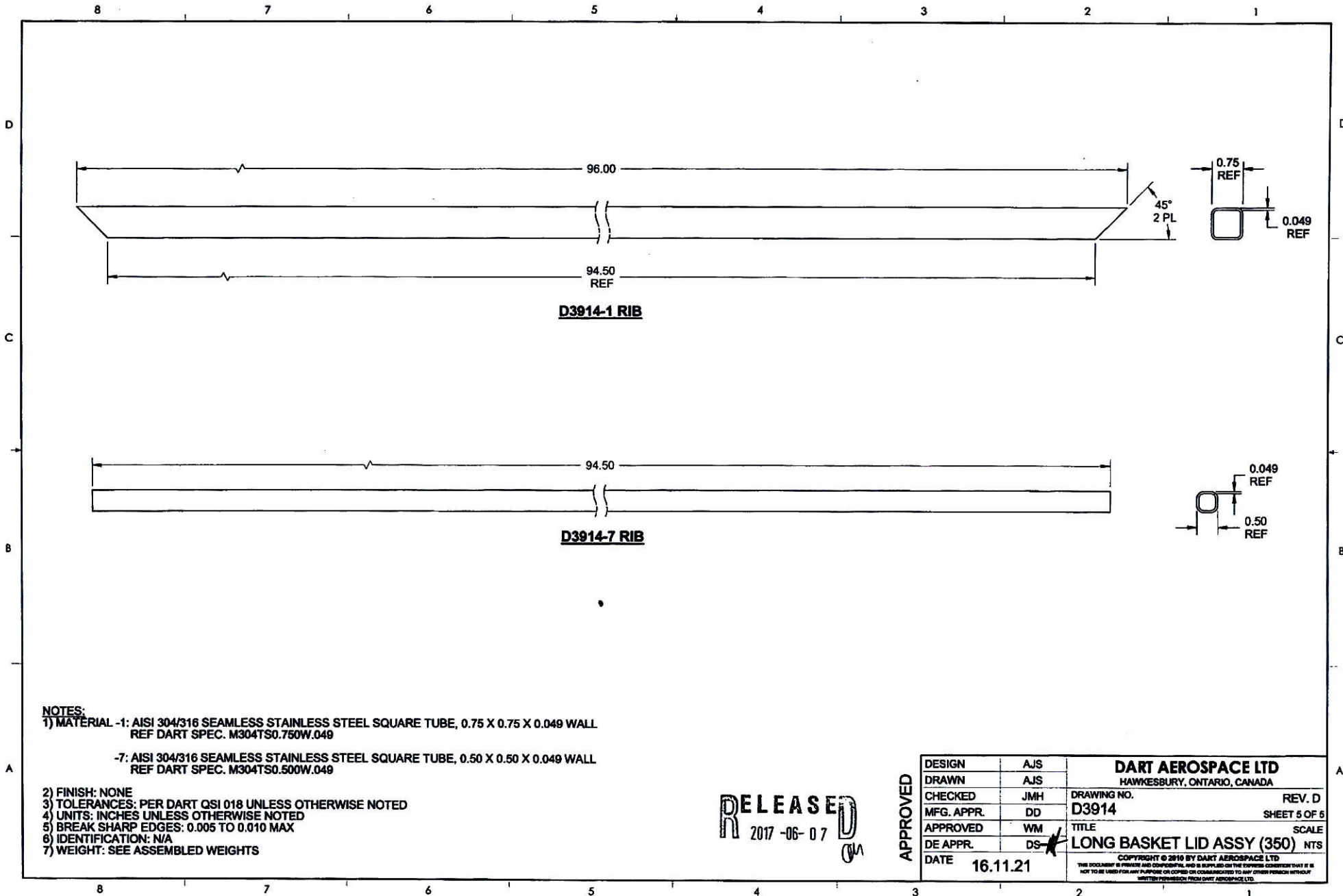


SECTION F-F
SCALE 2X

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XXXX DIMENSIONS 0.06 FOR D3914-101
 - 9) WELD PER DART QSI 004

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2017-06-07
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

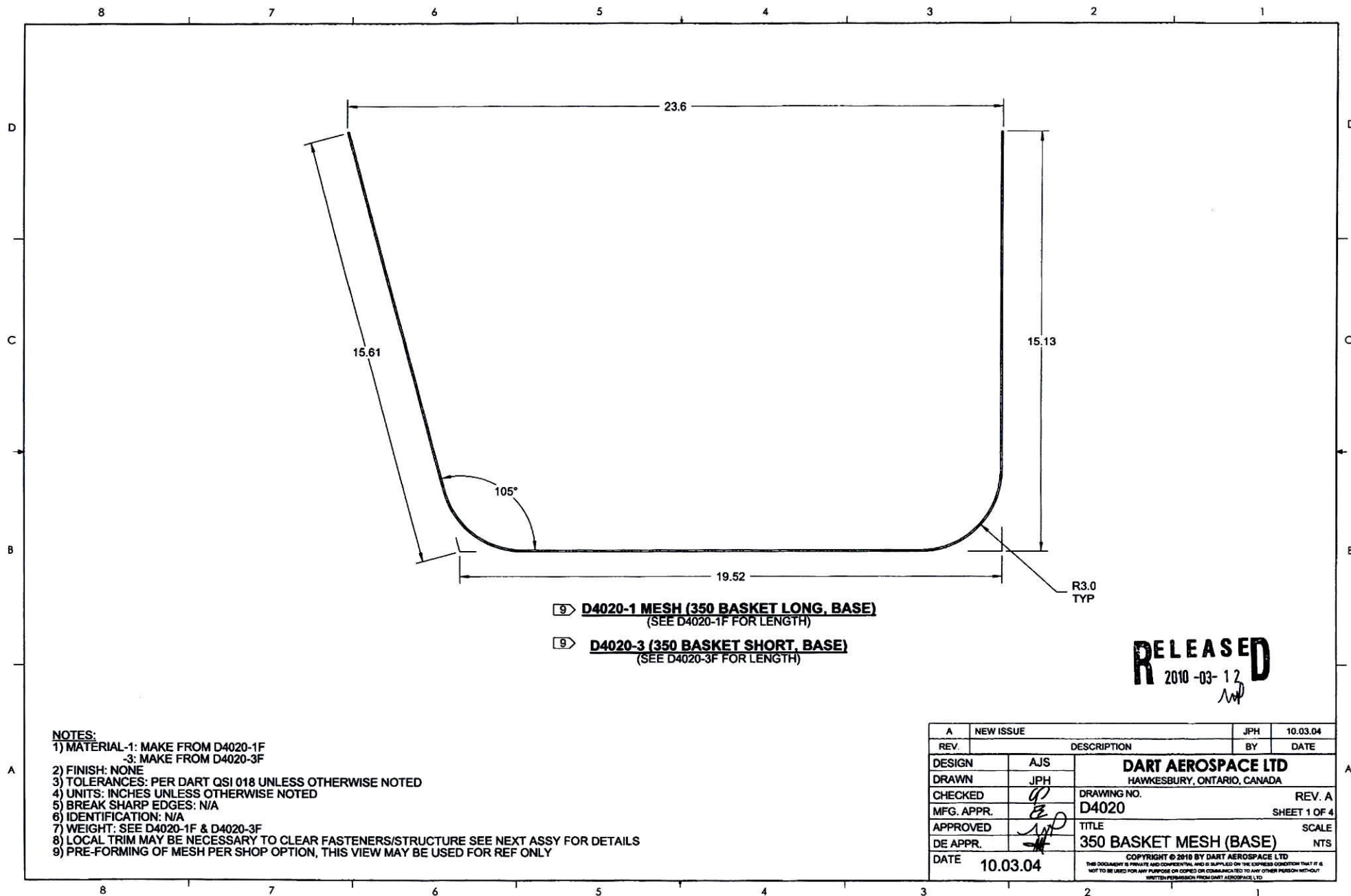
-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

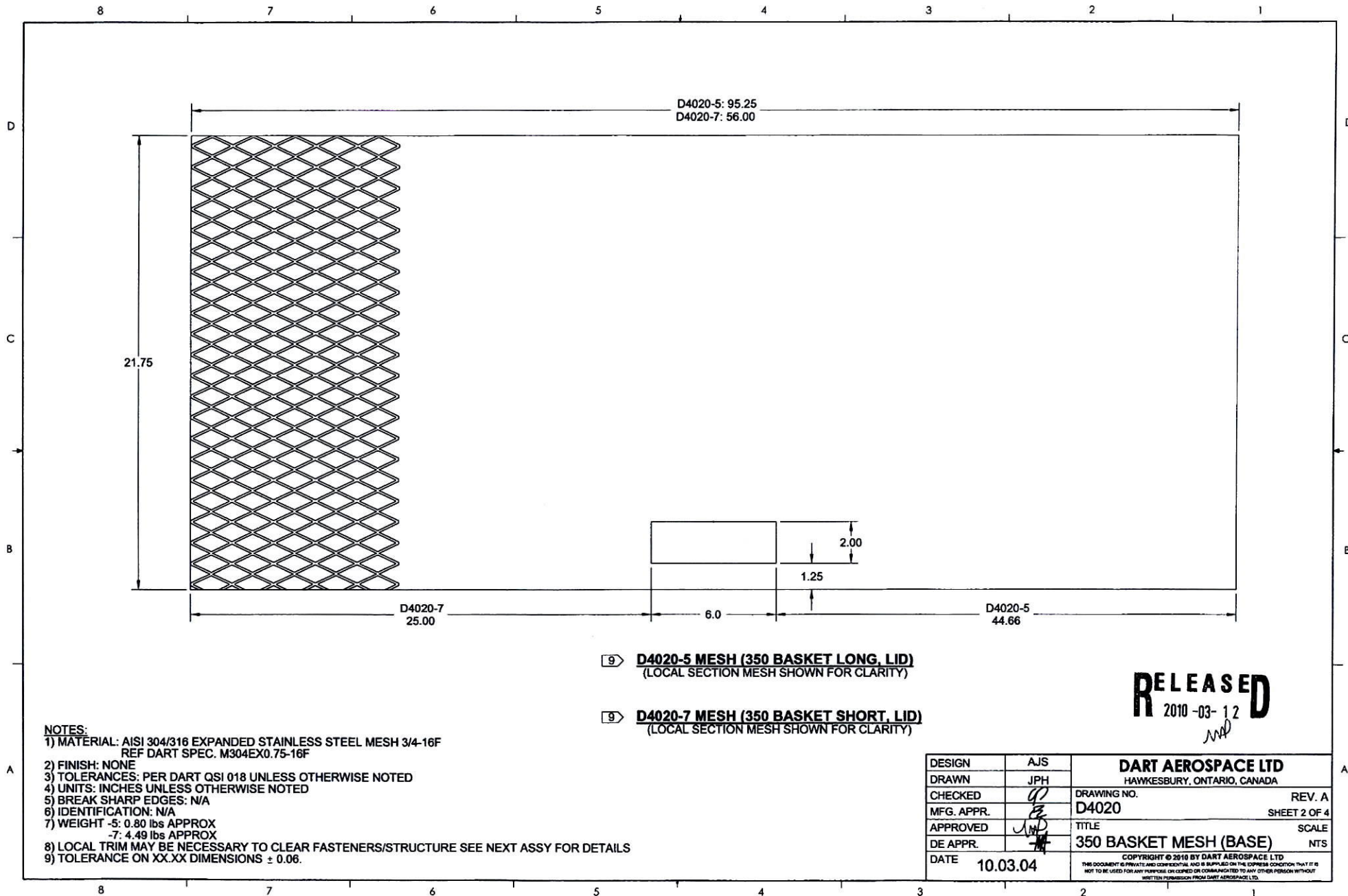
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2017-06-07

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3914	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET LID ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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9) **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

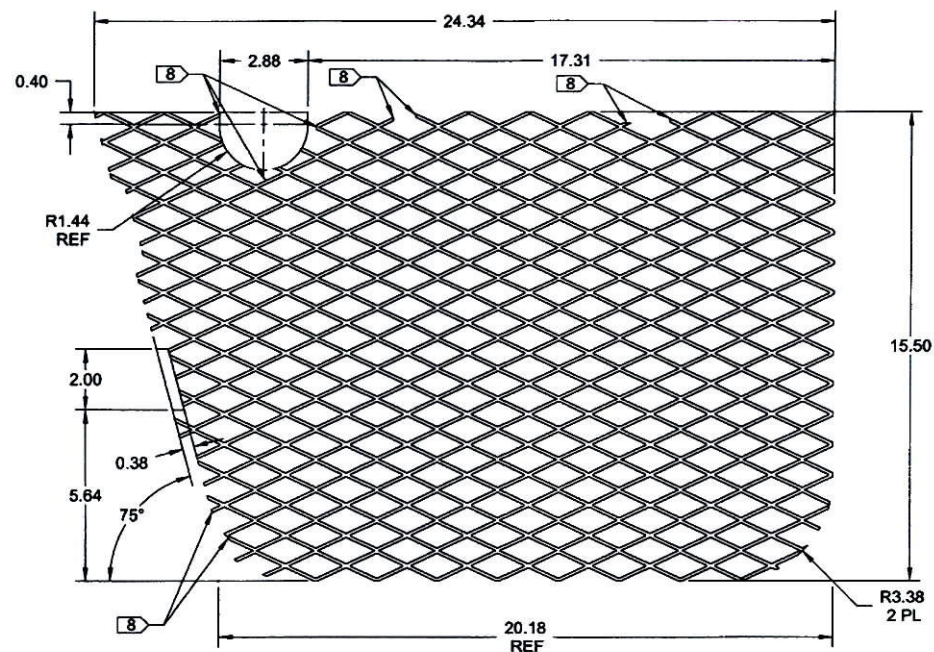
9) **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
MD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



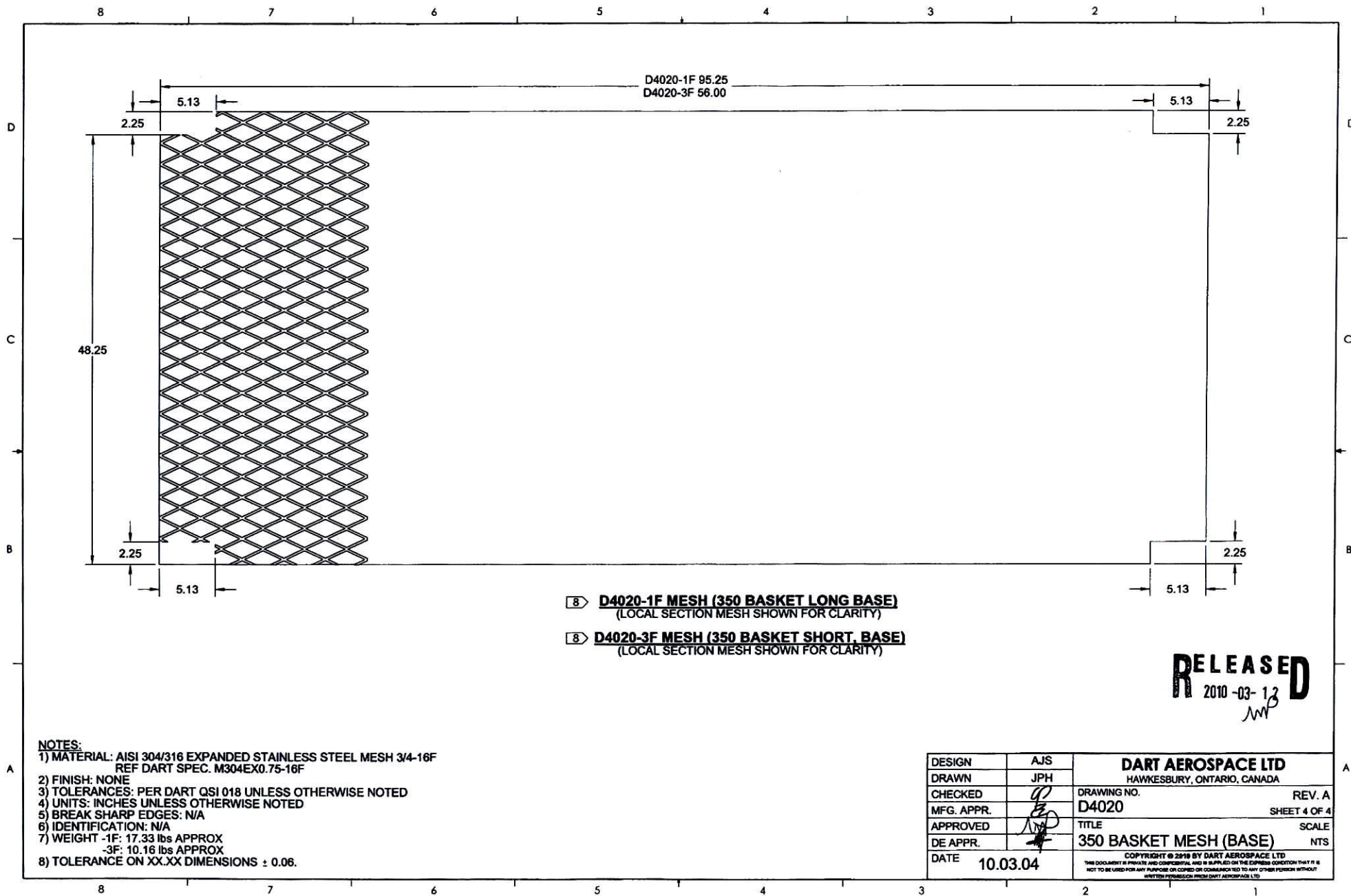
9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	
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- 8) **D4020-1F MESH (350 BASKET LONG BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 8) **D4020-3F MESH (350 BASKET SHORT, BASE)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-13
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NOTES:
 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
 REF DART SPEC. M304EX0.75-16F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT -1F: 17.33 lbs APPROX
 -3F: 10.16 lbs APPROX
 8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO. D4020	REV. A
MFG. APPR.	JP	SHEET 4 OF 4	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
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